Work Order ID 61306



Page 1

Insp.

Stamp

August 16, 2010 11:02:33 AM

Item ID: D4020-11 Accept Setup Start **Revision ID:** Stop End Mesh, Basket Item Name: Start Qty: 6.00 **Start Date:** 8/16/10 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 8/19/10 **Customer:** Reference: Run Start Date: 10/8/16 Tooling: **Process Plan:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Set Up/ Reject Operation Tool ID Tool # Plan Accept Reject Description Work Center ID Qty Number **Run Hours** Code **Qty** Draw Nbr **Revision Nbr** D4020 Α 100 0.00 FLOW WATER JET B 15-8-16 0.00 Waterjet Memo 1-Cut as per Rwg D4020 Dwg Rev: Rev FLOW CNC Waterjet Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 110 0.00 B10-8-16 0.00 QC Memo Quality Control ***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET*** 120 QC8- Inspect parts - second check 0.00

QC

Quality Control

Memo

0.00

***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON

BASKET***

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·							
		·				•		i .	
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:		W	ORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descri		tion B	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				

Work Order ID 61306

August 16, 2010 11:02:33 AM



Page 2

Item ID:

D4020-11

Accept

Setup Start

Run



Revision ID:

Item Name:

End Mesh, Basket

Start Date:

8/16/10

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____

Operation

Description

Date:

Tooling:

Date:

Date:

Start Stop

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Packaging Packaging

Required Date: 8/19/10

Memo

Identify as per dwg & Stock Location:

0.00

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Are table to the second of the						1 rod mg.	
				Alaman (194)					
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK ORE	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC					cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
								; ·	
						:		·	
		·							

Picklist Print

August 16, 2010 11:02:33 AM

Work Order ID: 61306

Parent Item:

D4020-11

Parent Item Name: End Mesh, Basket



Start Date: 8/16/10

Required Date: 8/19/10

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:B as IPP Rev:C 10.06.14 remove

IPP RevA: new issue DD 09.11.26 verified by;EC IPP per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06. cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304EX0.75-16F		Purchased	No			100	sf	974.6083	2.694	17.01474				, in . 10
										Į.	R10-	2-110		

Expanded Metal Flat SS

Location	Loc Qty	Loc Code	
MAT	974.608333		
114809	139.403243		
114853	11.80059		
115012	500		
115067	13.0125		
115171	7.3394		
115401	303.0526		<u>115401</u>



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		· · · · · · · · · · · · · · · · · · ·									
				·							
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQA:	Date: _					
	Res	olution:	Disposition:	QA: N/C Cld	osed:	Date: _					
NCR:			WORK ORDER NON-CON	IFORMANCE (NCR)						
		Description of NC	Corrective Action	n Section B	Verification	Annroyal	Annroval				

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
					-						
				·				i i			
		,									
	,					٠.					
				4. 							
			.	A Section 1	ł						

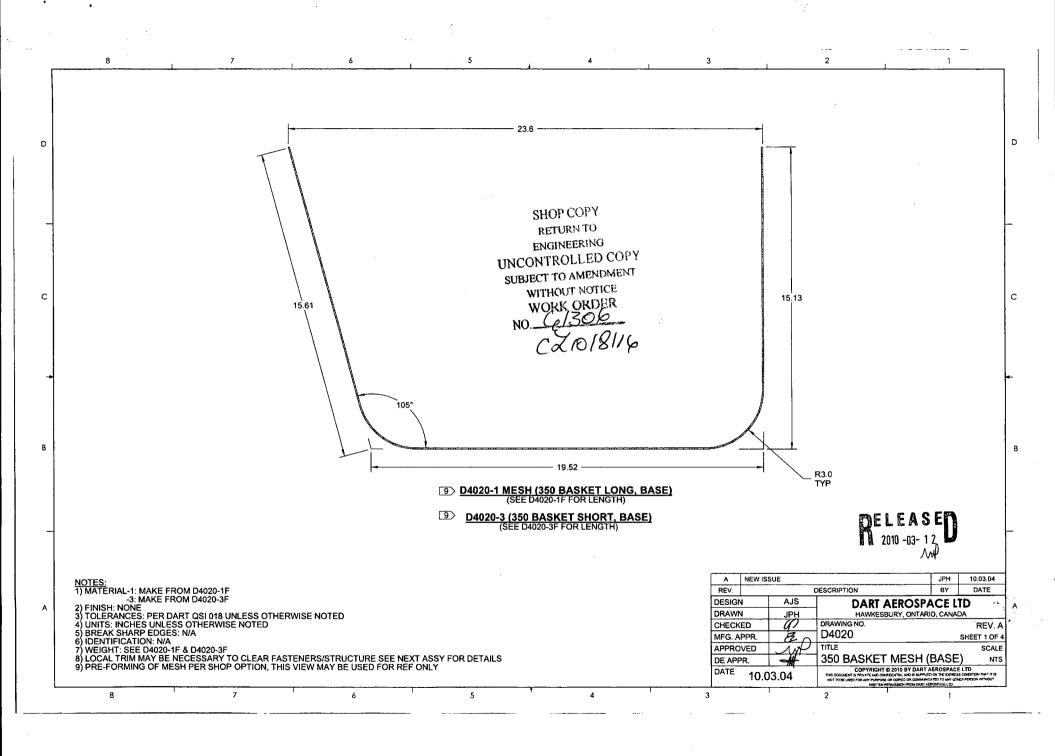
DART AEROSPACE LTD	Work Order:	6130G
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	34.34	æ			
2.88	+/-0.030	2.88	1/20			
17.31	+/-0.030	17.31	*			_
15.50	+/-0.030	15.50	kg			
20.18	+/-0.030	81.08	¥			
	_					
			=			
						·

Mea	sured by:	iR.	Audited by:		Preliminary Approval:	N/A
	Date:	10-8-16	Date:	10/08/16	Date:	N/A

Rev	Date	Change	Revi	sed b	<u>y</u>	Approve	≱d
Α	10.04.01	New Issue	KJ	10	\	1)	
В	10.08.03	Dimensions updated	KJ	48	七_		
		•		- 7		,	



Dart	Aeros	space	Ltd
------	-------	-------	-----

W/O:	1		W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	20 110 110 110 110 110 110 110 110 110 1
									20 3 3 4 3 4 3 4
		,	•			, , , ,			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C Clo	osed:	,	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section B			ation	Approval	Approvai
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
						_			
1	1								1

[,] H:\fFOFMS\Quality Assurance\approved QA\NCRWO RevE

D4020-5: 95.25 D4020-7: 56.00 SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT 21.75 WITHOUT NOTICE WORK ORDER NO. 61306 2.00 1.25 D4020-5 D4020-7 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) (LOCAL SECTION MESH SHOWN FOR CLARITY) MP NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. 9 CHECKED REV. A D4020 SHEET 2 OF 4

MFG. APPR. TITLE APPROVED 350 BASKET MESH (BASE) DE APPR COPYRIGHT © 2010 BY DART AEROSPACE LTD
IT IS PRIVATE AND CONFEDENTIAL AND IS SEPTLED ON THE EXPRESS CONDITION THAT IT IS
THE FOR ANY IMPROSE OR COMPET OR COMMANICATED TO ANY OTHER PERSON WITHOUT DATE 10.03.04

8

NTS

SCALE

0.40 8 R1.44 REF 15.50 2.00 5.64 R3.38 2 PL REF 9 D4020-11 END MESH, BASKET

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 6/306

С

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A

8

5) BREAK SHARP COURS. IN/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD JPH HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE SCALE APPROVED 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD DATE 10.03.04

3

5

6

